

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006133**Date Inspected:** 20-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Yu Dongping / You Qiguo / Li Lin			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	TOWER COMPONENTS		

Summary of Items Observed:

On this date, the Caltrans OSM Quality Assurance (QA) Inspector, "Victor" KS Narayan was present during the times noted above for observations relative to work performed.

Bay 11 – TOWER ASSEMBLY:

I. Lift 3 – Skin Plates' butt welding:

Weld process, SAW of butt weld joints located on PCMK: Lift 3-East Tower Skin "B" plate butt welds. The weld designation numbers and the welder was identified as follows.

ESD1-FBSA3-2A/C-2A(B) – CJP : The welder was identified as Wu Aixiang and the welder number was identified as 040772.

The ZPMC CWI was identified as Li Lin and the ABF representative was identified as Zhang Jicai. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2221-B-U3C-S-Z for CJP weld joint.

II. Struts' welding:

Weld process, SMAW of PJP weld joints located on PCMK: North Tower struts. The weld designation numbers and the welders were identified as follows.

ND1-A467-38M-6A(B), 4A(B), 1A(B): The welder was identified as Yang Zaihua and the welder # was identified as 040669.

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ND1-A468-23M-1-26A(B), 28A(B): The welder was identified as Cao Jianbin and the welder # was identified as 058009.

ND1-A468-23M-1-3A(B): The welder was identified as Zhu Zeyuan and the welder # was identified as 053916.

The ZPMC CWI was identified as Yu Dongping and the ABF representative was identified as Wang Chenjun. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-3212-Tc-U5b-1 for PJP weld joints.

III. Base shear plate stiffeners' welding:

Weld process, FCAW of PJP weld joints located on PCMK: Stiffener plates on BASE SHEAR PLATE of EAST TOWER. The weld designation numbers and the welders were identified as follows.

ED1-A29A/B-78: The welder was identified as Xu Hua and the welder number was identified as 049220.

ED1-A29A/B-79: The welder was identified as Li Haidong and the welder number was identified as 047701.

ED1-A29A/B-82: The welder was identified as Zhang Binghua and the welder number was identified as 053316.

ED1-A29A/B-83: The welder was identified as Wang Bing and the welder number was identified as 040713.

ED1-A29A/B-18: The welder was identified as Liu Jun and the welder number was identified as 202821.

ED1-A29A/B-19: The welder was identified as Li Zhaoqian and the welder number was identified as 048810.

ED1-A29A/B-22: The welder was identified as Wang Yinsheng and the welder number was identified as 040775.

ED1-A29A/B-23: The welder was identified as Huang Guoqi and the welder number was identified as 059525.

The ZPMC CWI was identified as You Qiguo and the ABF representative was identified as Xie Yan. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2332-Tc-P5-F.

ULTRASONIC TESTING:

Bay 11 – Tower Assembly:

This QA Inspector performed 10% UT of area previously tested by ZPMC UT personnel. This QA Inspector generated a TL-6027 UT report on this date. The member was identified as Lift 2 – West Tower Skin “D” T weld joint.

The weld designation numbers are as follows.

WSD1-SA209 D/D-1 A/B

WSD1-SA209 D/D-7 A/B

WSD1-SA209 D/D-21 A/B

This QA Inspector performed 10% UT of area previously tested by ZPMC UT personnel. This QA Inspector generated a TL-6027 UT report on this date. The member was identified as Lift 3 – West Tower butt weld joint.

The weld designation number is as follows.

WSD1-SA209 D/D-1A/B

Unless otherwise noted, all observations on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

This report is for the purpose of determining conformance with the contract documents and is not for the purpose

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of making repair or fit for purpose recommendations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod (134-825-70045), who represents the Office of Structural Materials for your project.

Inspected By: Narayan,Victor

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer